

Date: Wednesday, 28/01/2009 4:59:49 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAT TRACK
Job Number :	45322		
Estimate Number :	10090		
P.O. Number :		Part Number :	D3158
This Issue :	28/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3158 REV. A
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<u>JUD 09.01.29</u>	Due Date :	10/02/2009
Comment :	Est: A 02.05.17 New Issue NG	Qty:	<u>200</u> Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8264

Seal as per dwg D3158

Possible Supplier: Raychem p/n RNF-100-1-CL

Material: Heat shrinkable insulation sleeving.

Material release note required

C209/02/24200gft

2.0	RNF1001CL	Heat Shrink
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Comment: Qty.: 1.0000 f(s)/Unit Total: 50.0000 f(s)

HEAT SHRINK

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

P4/4/3 200 88 09/03/30 X100

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect diimensions as per Dwg D3158 and attached certification

50gft 6 (+200 fth)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 4109/1/16200gft

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 4:59:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT TRACK

Job Number: 45322

Part Number: D3158

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

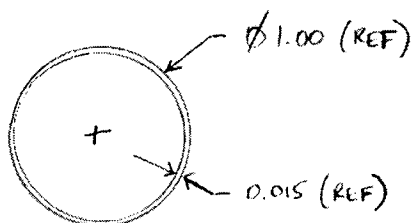
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3158	REV. A SHEET 1 OF 1
DATE 02.05.13		TITLE HEAT SHRINK TUBING	SCALE N.T.S.
A	02.05.13	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3158-XXX HEAT SHRINK TUBING

XXX = LENGTH IN TENTHS OF INCHES

EG. 3.5" LONG = D3158-035

10.0" LONG = D3158-100

MATERIAL: HEAT SHRINKABLE INSULATION SLEEVING

POSSIBLE SUPPLIER: RAYCHEM P/N RNF-100-1-CL

TOLERANCES PER DART QST 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45322

RELEASED
02.05.13

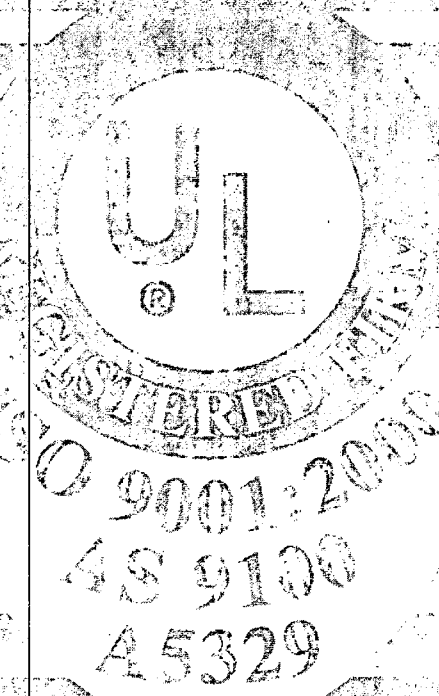
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Phone: (631) 435-3535 Fax: (631) 435-3533

* PACKING/INVOICE *
*****IQC003VW
03/30/09S
O DART AEROSPACE LTD
L 1270 ABERDEEN ST.
D HAWKESBURY, ONT
1 CANADA K6A1K7
OS
H DART AEROSPACE LTD
I 1270 ABERDEEN ST.
P HAWKESBURY, ONT
T CANADA K6A1K7
OP.O. #: PO00008264
OUR SALE # SQC00JPD
TERMS: NET 45 DAYSSHIP MODE: FEDEX INTL GROUND
NO. CARTONS: 0 SC090890B4
F.O.B: 1

QUANTITY ORDERED	U/M	QUANTITY SHIPPED	BALANCE DUE	PART NO. & DESCRIPTION	UNIT PRICE	TOTAL
200	EA	200	0	M23053/5-210-C SLEEVE Customer #: RNF1001CL Cust Line: 2 LOT 201339614 QTY: 200 MANF: TYCO ELEC./RAYC TEST: MFG COFC	1.35000	270.00
						
Total Weight				.000 TOTAL		270.000

To Remit via wire: M&T Bank 401 Broad Hollow Rd. Melville NY 11747
Acct Name: Wells Fargo Business Credit for UFC Aerospace Corp.
Acct #: 017066309 Bank ABA Code: 022000046 Swift Code: MANTUS 33

All claims for error, shortage, or damage must be made within 7 days after receipt of goods. Our liability is limited to replacing the material or refunding the invoice value of the material sold. Returns must have an authorization number issued by UFC Aerospace Corp., and must be affixed to all return containers. Copies of test reports/manufacturer's certifications are subject to a special handling charge if not requested at the time the order is initially placed.

First Due invoices are subject to a 1½% (18% annual) service charge, where lawful, plus attorney and/or collection agency fees if collection becomes necessary.

Form #UFC 003

CERTIFICATE OF COMPLIANCE

THE ABOVE MATERIAL HAS BEEN INSPECTED AND IS IN ACCORDANCE WITH ALL APPLICABLE PRINTS AND SPECIFICATION REQUIREMENTS. NO REWORK HAS BEEN DONE TO THESE PARTS. ALL MANUFACTURER CERTIFICATIONS ARE ON FILE AT UFC AND AVAILABLE FOR REVIEW.

By


DIRECTOR OF QUALITY ASSURANCE

Powell Electronics
200 Commodore Dr
Swedesboro NJ 08085-1270

Certificate of Conformance

Page: 1

Date
03/05/2009
Purchase order item
4500162647/6
Delivery item
62254466/1
Order item
3012518240/6
Customer Number
248864
Customer Specification / Rev.
SAE-AMS-DTL-23053/5/JUL 1999

It is hereby certified that all items listed are in compliance with the quality acceptance requirements of the given specification and/or material description.
Test reports substantiating this certificate are available.

609/04/09

MIL-LT and Versafit meet both class 1 and 3 of SAE-AMS-DTL-23053/5.
MIL-LT= RT-1171 Issue 7, Versafit= RW-3009 Issue 2, RNF-100= RT-350 Issue 16. The sleeving, when stored at 18 to 35 deg. C for 5 years, shall conform to the dimensional requirements specified.

Our material description
Your Material Reference

Batch#

Quantity

152125-000 RNF-100-1-CL-FSP
M23053/5-210-C

201339614

200 FT

DC-02/2009

Robert Avants

Robert Avants
Quality Assurance Representative
US Thermofit Tubing





Tyco Electronics
300 Constitution Drive
Menlo Park, CA. 94025-1164
Tel: (650) 361-3333 Fax: (650) 361-XXXX

Powell Electronics
200 Commodore Dr
Swedesboro NJ 08085-1270

Certification and Test Report

Page: 1 / 1

Date
03/05/2009
Purchase order item
4500162647 6
Delivery item
62254466 1
Order item
3012518240 6
Customer number
248864
Customer Specification / Rev.
SAE-AMS-DTL-23053/5/JUL 1999

Our Material Description Your Material Reference	Batch#	Quantity
152125-000 RNF-100-1-CL-FSP M23053/5-210-C	201339614	200.000 FT <i>S orladob</i>

Certificate of Compliance

It is hereby certified that all items listed are in compliance with the quality acceptance requirements of the given specification and/or material description.

MIL-LT and Versafit meet both class 1 and 3 of SAE-AMS-DTL-23053/5.
MIL-LT = RT-1171 Issue 7, Versafit = RW-3009 Issue 2, RNF-100 = RT-350 Issue 16. The sleeving, when stored at 18 to 35 deg. C for 5 years, shall conform to the dimensional requirements specified.

Test Report

Test Name	Test Results Imperial	Test Results Metric	Pass/Fail
Recovered ID (Jacket)	0.465 in	11.81 mm	Pass
Recovered Wall (Jacket)	0.035 in	0.89 mm	Pass
Expanded ID (Jacket)	1.090 in	27.69 mm	Pass
Concentricity (Jacket)	85 %		Pass
Longitudinal Change	-3.0 %		Pass
2% Secant Modulus (Expanded)	15583 psi	107 MPa	Pass
Tensile Strength	2973 psi	20 MPa	Pass
Ultimate Elongation	400 %		Pass
Clarity Stability			Pass
HEAT SHOCK			Pass
Low Temperature Flexibility			Pass

Note: This test report may include results not required in the above specification.
When stored at 18 - 35 deg C, material will meet the dimensional attributes of the listed specification.

Robert Avants

Robert Avants
Quality Assurance Representative
US Thermofit Tubing

